

535

DART AEROSPACE LTD	Work Order:	23912
Description: Bearpaw Kit (48" x 19") 205/430	Part Number:	K10015
Dwg: D2521 Rev. I	Qty:	10 Kits
Ref: K10015 Rev. A; DSK086-6 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																								
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required	SL	05/08/04	10																																								
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 (Bag Bluefiles separately)	SL 05/08/04	05-08-19	10																																								
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick (+0.030/-0.000) per DSK086-6 Material: Black UHMW 1" (MUHMWB10) Batch: <u>M18612</u>	SL 05/10/12		10																																								
4	MV	Inspect material for defects or damage prior to machining	SL	05/10/17	10																																								
5	MV	Machine as per Folio FA222 and Dwg D2521 Identify as D2521 Dwg Rev: <u>I</u> Folio Rev: <u>E</u>	SL	05/10/17	10																																								
6	QC2	Inspect parts as they come off the CNC machine	SL	05/10/17	10																																								
7	MV	Deburr	SL	05/10/17	10																																								
8	QC8 & 5	Second inspection	SL	05/10/17	10																																								
9	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>8</td><td>D2182B055</td><td>Rubber Cushion</td><td>B 21872</td></tr><tr><td>16</td><td>D2274</td><td>Radius Block</td><td>B 22494 / B 23174</td></tr><tr><td>2</td><td>D2521</td><td>Bearpaw</td><td>B 23912</td></tr><tr><td>16</td><td>D2529</td><td>Washer</td><td>B 22504</td></tr><tr><td>8</td><td>D2947</td><td>Clamp</td><td>B 21588</td></tr><tr><td>16</td><td>AN4-15A</td><td>Bolt</td><td>M16067</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M17566</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15924</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table>	Qty	Part Number	Description	Batch	8	D2182B055	Rubber Cushion	B 21872	16	D2274	Radius Block	B 22494 / B 23174	2	D2521	Bearpaw	B 23912	16	D2529	Washer	B 22504	8	D2947	Clamp	B 21588	16	AN4-15A	Bolt	M16067	16	AN960JD416	Washer	M17566	16	MS21042L4	Nut (or -4)	M15924	1	Paperwork package from Step 2			SL	05/08/31	10
Qty	Part Number	Description	Batch																																										
8	D2182B055	Rubber Cushion	B 21872																																										
16	D2274	Radius Block	B 22494 / B 23174																																										
2	D2521	Bearpaw	B 23912																																										
16	D2529	Washer	B 22504																																										
8	D2947	Clamp	B 21588																																										
16	AN4-15A	Bolt	M16067																																										
16	AN960JD416	Washer	M17566																																										
16	MS21042L4	Nut (or -4)	M15924																																										
1	Paperwork package from Step 2																																												
10	QC4	Inspect Kit for 100% Completeness on the W/O	SL	05/10/17	10																																								
11	PK	Identify and pack for shipping as per PPP K10015 REV. D	SL	05/10/17	10																																								
12	AC	Cost / part: <u>406.47</u>	SL	05/10/18	10																																								
13	DC	Close W/O <u>402.27</u> Inspect Level 21	SL	05/10/18	10																																								

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	
C	04.02.17	Tolerance added to Step 3	KJ/JLM	
D	05.06.20	Forming removed	KJ/JLM	

RCP0000554

RELEASED

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 05/10/18

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: I		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Same measurements

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.00	+/-0.030	1.0035	/			
B	5.60	+/-0.030	5.596	/			
C	11.50	+/-0.030	11.50	/			
D	10.250	+/-0.010	10.250	/			
E	13.250	+/-0.010	13.250	/			
F	8.500	+/-0.010	8.500	/			
G	22.13	+/-0.030	22.150	/			
H	8.75	+/-0.030	8.75	/			
I	44.50	+/-0.030	44.50	/			
J	6.69	+/-0.030	6.687	/			
K	5.63	+/-0.030	5.620	/			
L	7.000	+/-0.030	7.00	/			
M	5.000	+/-0.010	5.000	/			
N	4.00	+/-0.030	4.00	/			
O	6.63	+/-0.030	6.625	/			
P	19.00	+/-0.030	19.00	/			
Q	0.31 x 45°	+/-0.030	.300 x 45°	/			
R	0.19 x 45°	+/-0.030	.200 x 45°	/			
S	0.50 x 45°	+/-0.030	.50 x 45°	/			
T	0.38 x 45°	+/-0.030	.38 x 45°	/			
U	0.063 x 45°	+0.030/-0.010	.065 x 45°	/			
V	Ø0.260	+0.005/-0.000	Ø.260	/			
W	Ø0.93	+/-0.030	Ø.928	/			
X	0.30	+0.030/-0.010	.307	/			
Y	0.37	+0.030/-0.010	.379	/			
Z	0.75	+0.030/-0.010	.760	/			
AA	0.25	+0.030/-0.010	.254	/			
AB	4.00	+/-0.030	3.998	/			
AC	6.62	+/-0.030	6.625	/			
AD	0.95	+0.030/-0.010	.959	/			
AE	0.37	+0.030/-0.010	.379	/			
AF	3.40	+0.030/-0.010					
AG	6.63	+/-0.030	6.625	/			

Measured by: SD	Audited by: 36	Prototype Approval:	N/A
Date: 05.10.13	Date: 05.10.14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10015	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	

RELEASED
 05.06.15

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ONTARIO, CANADA

REV. 1

APPROVED

DRAWING NO.

SHEET 1 OF 2

DATE _____

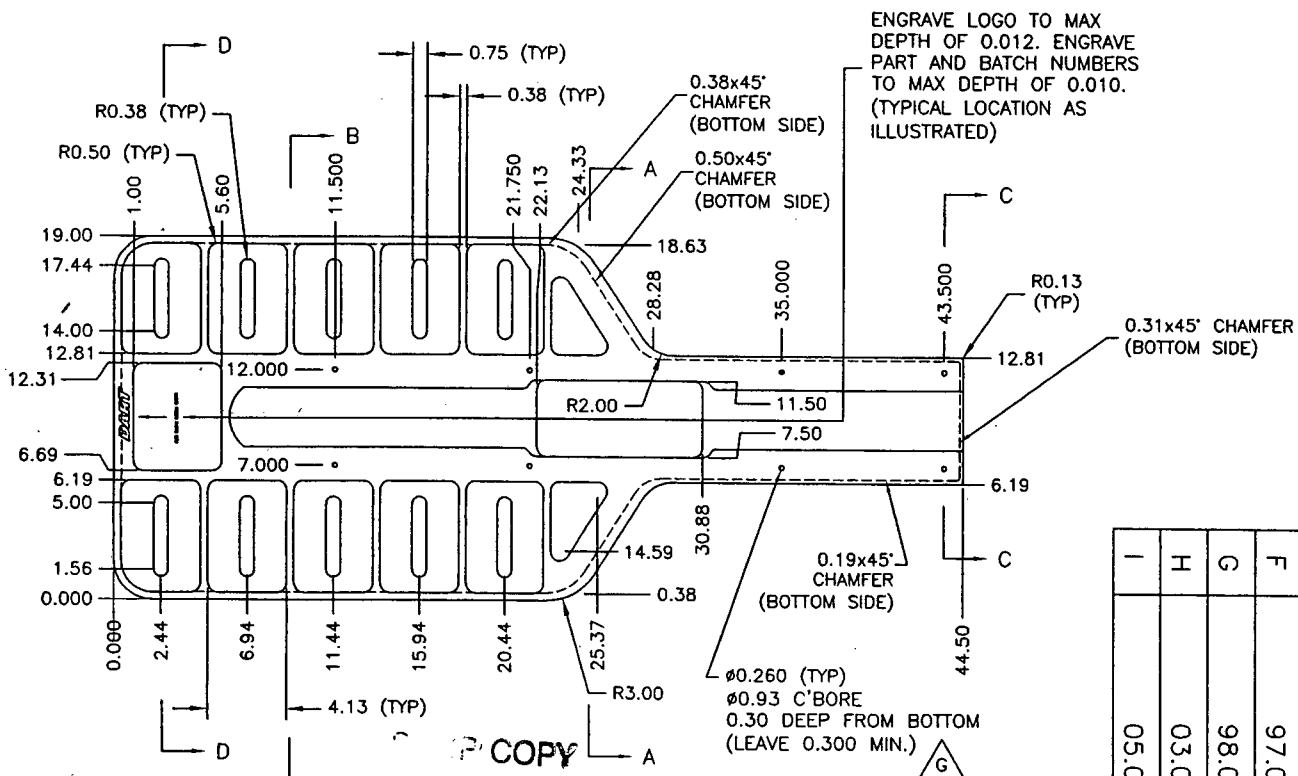
TITLE

05.05.20

205 BEARPAW

1:10

RELEASED
05-06-13



— B RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23912

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

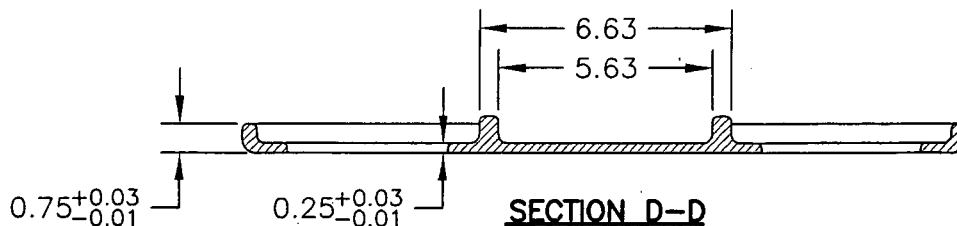
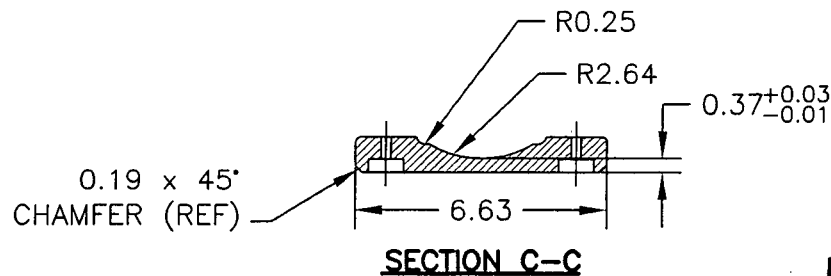
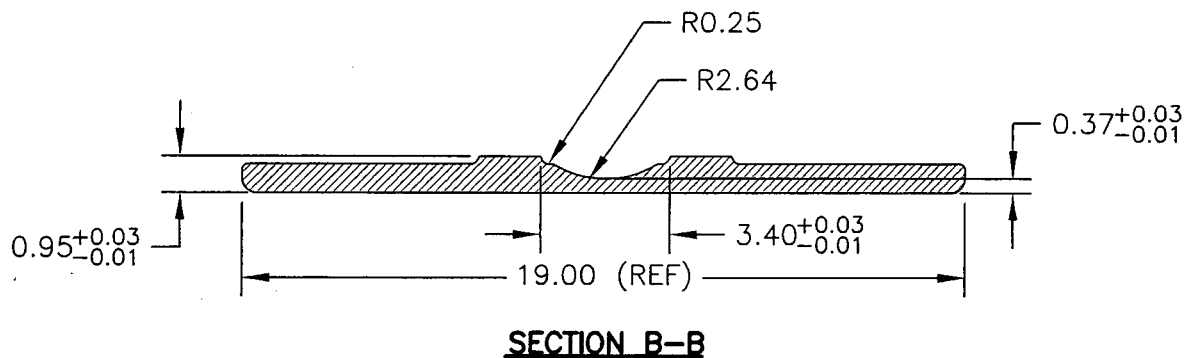
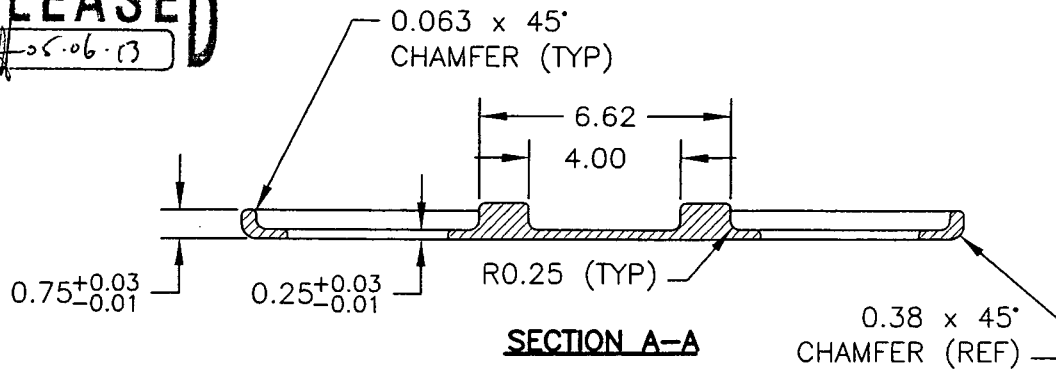
Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2521	REV. 1 SHEET 2 OF 2
DATE 05.05.20		TITLE 205 BEARPAW	SCALE 1:5

RELEASED
#56-06-13



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ACCEPTANCE
WITHOUT NOTICE
WORK ORDER
NO. 23912

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

00000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 02, 2005
01:38 pm

Work Order No	: 0023912	Department Code:	
Project Name	: K10015	Burden Flags	: NNNNNNNN
Project For	: WK535	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *K10015	Invoice Number	:
Description	: Bearpaw Kit	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 10	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-02-05		
Est Finish Date	: 08-31-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00